

## Description

### Method for the Production of a Shoe

The invention relates to a method for the production of shoe with a sole, created within a casting mold featuring an upper casting mold edge, and an upper piece, which is formed of an upper and an inner sole that is fastened to the upper and bonded to the sole in the assembled shoe, which projects towards the side with an inner sole edge, wherein a fillet is introduced into the shoe upper piece that is comprised of inner sole and upper and the shoe upper piece now with fillet inserted, after filling in the shoe base material to seal the casting mold, is placed with its inner sole edge on the casting mold edge and to seal the casting mold by means of a pressing frame is pressed from above on the inner sole edge and thus on the casting mold edge so that a connection between the inner sole and the sole is then produced in the casting mold by the fluid shoe base material, and in which the inner sole edge is separated after demolding the shoe.

A method of foregoing type is the subject of DE 101 56 529 A1. In the case of the known method, the inner sole edge and the edge of the upper rest on top of each other on the edge of the casting mold. The edge of the upper is folded towards the outside for this purpose. As a result, one sees the folded edge of the upper on the side in the finished shoe just like with a shoe with a flexible design. If the shoe in question is a sandal or another shoe in which the upper does not run over the entire outside periphery of the shoe sole, then, because of this design, one sees the edge of the inner sole in some areas when

viewed from above and in other areas the edge of the upper that has been folded to the outside, which produces an appearance that is often considered to be disadvantageous.

The invention is based on the objective of developing a method of the type cited at the outset in such a way that the edge of the inner sole material remains visible all around in the finished shoe.

This objective is attained in accordance with the invention in that only the inner sole edge rests on the edge of the casting mold and the upper is fixed internally to the inner sole such that the shoe base material presses the inner sole against the edge of the upper that is adjacent to the fillet.

As a result of such a method, the edge of the inner sole leather remains visible all around, lending the finished shoe a very high-quality optical appearance. In contrast to expectations, the edge of the upper does not project against the inner sole towards the foot, because the expanding shoe base material presses the inner sole so strongly against the edge of the upper and the fillet that the edge of the upper is pressed into the material of the inner sole. As a result, no scarfing of the upper parts is required after the expanding of the shoe sole.

The upper is connected especially solidly to the inner sole if, according to a development of the method in accordance with the invention, the edge of the upper is connected to the inner sole by a seam.

The method in accordance with the invention is particularly advantageously applicable if the upper is the strap of a sandal.

The invention allows for various embodiments. In order to elucidate the basic principle of the invention the figures depict the following and are described below:

- Fig. 1     a cross section through a casting mold with a shoe inserted into it  
Fig. 2     an enlarged section from Fig. 1.

The drawing shows a casting mold 1 into which a sole tread 2 made of wear-resistant material that completely fills out the free interior cross section of the mold was first inserted from above. Then one fills a sole material into the casting mold 1, in particular a cork/latex mixture, which creates an insole 3 in a finished state. This insole 3 forms a shoe sole 4 together with the sole tread 2.

The insole 3 is covered towards the top by an inner sole 5, which is connected to an upper 7 by means of a seam 6, thereby creating a shoe upper piece 8. The required shape of the shoe upper piece 8 is created by a fillet 9 inserted into the upper piece.

Important to the method is that the upper 7 has an upper edge 12, which, in contrast to the method according to the cited DE 101 56 529 A1, is not folded to the outside, but runs on the inner side of the inner sole 5 in the plane of the edge region of the insole 3 and is sewed to it there by the seam 6.

After insertion of the sole tread 2 and filling in the cork/latex mixture that forms the insole 3, the shoe upper piece 8 with the fillet 9 is placed from above into the casting mold 1.

In doing so, an inner sole edge 10 ends up on the upper edge of the casting mold 11. A pressing frame 13 is then placed on the inner sole edge 10 from above so that the pressing frame 13 can press the inner sole edge 10 on the casting mold edge 11 thereby closing and sealing the casting mold 1. Finally, the casting mold 1 is heated, which compresses the cork/latex mixture and produces close contact between the cork/latex mixture and the inner sole 5 and the sole tread 2 thereby reliably connecting these parts.

During heating pressure is exerted between the base of the fillet 9 and the cork/latex mixture. As a result, the edge presses into the inner sole 5, which itself presses into an indentation 14 forming in the cork/latex mixture. Although the edge of the upper 7 is not beveled, but cut off straight, the result is a smoother transition between the surface of the upper 7 facing the foot and the inner sole 5 since the upper 7 is pressed into the inner sole corresponding to the thickness of its material. Fig. 2 shows an enlarged depiction of this. A step in the transition between the upper 7 and the inner sole 5, which would be unpleasantly noticeable when the shoe is worn on the foot, does not appear.

In addition, the pressing frame 13 projects over the edge of the edge of the casting mold rim 11 at least in the region of the upper 7 so that an adhesive edge 15 lying outside of the upper 7 is formed, at which the edge of inner sole 5 is directly glued to the insole 3.

After cooling the casting mold 1 and demolding the shoe upper piece 8, the projecting inner sole edge 10 is cut off, thereby completing the shoe.

**List of Reference Numbers**

- 1 Casting mold
- 2 Sole tread
- 3 Insole
- 4 Shoe sole
- 5 Inner sole
  
- 6 Seam
- 7 Upper
- 8 Shoe upper piece
- 9 Fillet
- 10 Inner sole edge
  
- 11 Casting mold edge
- 12 Edge of upper
- 13 Pressing frame
- 14 Indentation
- 15 Adhesive edge